

Amendments to the Claims

1. (Original) A method of forming a pipe comprising the steps of feeding a work having a hole between an upper roll and a pair of lower rolls of a bending machine with said lower rolls being parallel to each other and relative to said upper roll, moving the work by the rotation of said lower rolls while supporting it with said upper and lower rolls, and forming a pipe by bending the work under pressure of said upper and lower rolls, wherein the forming step comprises a rough forming step in which the work is formed into a pipe having a rough radius and a fine forming step followed by said rough forming for finishing the pipe to a required radius, wherein in the rough forming step, the work is bent by pressing with said upper and lower rolls so that a required radius will be obtained at a hole portion, and in the fine forming step, no bending action is applied to said hole portion and the work is rolled by pressing with said upper and lower rolls so that at portion other than said hole portion, the radius will coincide with that at said hole portion.

2. (Original) A method of forming a pipe as claimed in claim 1 wherein if a work having holes of different sizes is formed into a pipe, the work is formed into a pipe with the larger-diameter hole regarded as said hole of the work and the smaller-diameter hole portion regarded as portion other than said hole portion.

3. (Currently amended) A method of forming a pipe as claimed in claim 1 ~~or 2~~ wherein said rough forming step comprises the steps of feeding the work while pressing it between said upper and lower rolls with said upper roll shifted to one side from the center between said lower rolls to roll the work, and pressing for end bending at one end of the work in a going path, then returning the work while pressing it between said upper and lower

rolls with said upper roll shifted to the other side to roll the work, and pressing for end bending at the other end of the work in the return path.

4. (Original) A method of forming a pipe as claimed in claim 3 wherein in said rough forming step, every time the working in the return path is carried out, the distance between said upper roll and said lower rolls is reduced in a stepwise manner so that the radius of the finished product will be obtained at the hole portion of the work.

5. (Original) A device for forming a pipe comprising an upper roll and a pair of lower rolls which are parallel to each other and are arranged so as to vertically oppose each other, one of said upper and lower rolls being provided so as to be movable vertically and horizontally relative to the other, actuators for rotating, raising and lowering said rolls so as to move while supporting a work with holes which is supplied between said upper and lower rolls by the rotation of the rolls, and simultaneously bend it under the pressure of the rolls to form a pipe, a control unit for controlling said actuators, said control including a control program for controlling a pipe forming step comprising a rough forming step in which the work is formed into a rough radius and a fine forming step followed by said rough forming step for finishing it to a required radius, wherein in the rough forming step, the work is bent by pressing with said upper and lower rolls so that a required diameter will be obtained at the hole portions, and in the fine forming step, no bending action is applied to the hole portion, and the work is rolled by pressing with said upper and lower rolls so that portions other than the hole portions, the pipe radius coincides with that of the hole portions.

6. (Original) A device for forming a pipe as claimed in claim 5 wherein said upper roll and said lower rolls which are parallel thereto and parallel to each other are arranged.

7. (New) A method of forming a pipe as claimed in claim 2 wherein said rough forming step comprises the steps of feeding the work while pressing it between said upper and lower rolls with said upper roll shifted to one side from the center between said lower rolls to roll the work, and pressing for end bending at one end of the work in a going path, then returning the work while pressing it between said upper and lower rolls with said upper roll shifted to the other side to roll the work, and pressing for end bending at the other end of the work in the return path.